

Date: Friday, 10/5/2007 10:58:47 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: OUTER FWD SADDLE		
Job Number	: 35033			Part Number	: D5951		
Estimate Number	: 11076			Drawing Number	: D5951 REV.B		
P.O. Number	: N/A			Project Number	: N/A		
This Issue	: 10/5/2007 S.O. No. : N/A			Drawing Revision	: B		
Prsh Rev.	: NC			Material	: N/A		
First Issue	: N/A			Due Date	: 10/23/2007 Qty: 8 Um: Each		
Previous Run	: 32300						
Written By							
Checked & Approved By							
Comment	Est Rev:E	Re-Format	05-11-29	JLM			
	Est Rev:E	Re-Format	05-11-29	JLM			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101013	Saddle billet	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) D6101-013 (7075-T7351) Size 2.50" x 10.10" X 8.25" (Grain along 10.10") Batch: B31390	
			8.5 07/10/30
2.0	HAAS3	HAAS CNC VERTICAL MACHINING #3	
		Comment: HAAS CNC VERTICAL MACHINING #3	
		1-Machine as per folio D5951, Ensure Batch Number is entered	
		2-Machine Keyway	
		3-Deburr & Tumble	8.5 07/10/30
3.0	QC1	INSPECT ALL DIM TO DIM SHEET	
		Comment: INSPECT ALL DIM TO DIM SHEET	8.5 07/10/30
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	J.L 07/11/01
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
		Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1	MJ 07-11-02 (F)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 01/10/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 10/5/2007 10:58:47 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OUTER FWD SADDLE

Job Number: 35033

Part Number: D5951

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 POWDER COATING

POWDER COATING



M105914



(X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m-f 07/11/05

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



MJ



(X)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07-11-05

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST428

(X)

07/11/05 AS

10

(8)

9.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/11/06

Job Completion



U 07.11.06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order:	35033
Description: Outer Fwd Saddle				Part Number:	D5951
Inspection Dwg: D5951 Rev: B				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.437	0.444		.441	.444	.441	.441		
B	1.745	1.755		1.746	1.752	1.747	1.749		
C	5.245	5.255		5.249	5.251	5.252	5.250		
D	6.995	7.005		7.000	7.002	7.000	7.001		
E	5.245	5.255		5.244	5.250	5.250	5.250		
F	4.745	4.755		4.750	4.750	4.750	4.750		
G	0.315	0.322		.318	.318	.318	.319		
H	1.522	1.532		1.529	1.527	1.526	1.526		
I	3.048	3.058		3.055	3.055	3.055	3.055		
J	4.575	4.585		4.582	4.580	4.580	4.580		
K	0.312	0.319		.318	.319	.318	.319		
L	0.495	0.505		.502	.500	.500	.500		
M	0.490	0.510		.505	.506	.508	.508		
N	1.615	1.635		1.624	1.624	1.624	1.624		
O	7.990	8.010		8.005	8.002	8.003	8.003		
P	2.240	2.260		2.249	2.250	2.250	2.250		
Q	0.307	0.312		.309	.309	.309	.309		
R	0.760	0.765		.760	.760	.760	.760		
S	0.490	0.510		.500	.500	.500	.500		
T	1.375	1.395		1.381	1.381	1.380	1.380		
U	2.000	2.020		2.002	2.001	2.001	2.001		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>J.F.</i>	Audited by:	<i>J.L.</i>
Date:	<i>07/10/30</i>	Date:	<i>07/11/01</i>

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	
C	06.12.06	Dimensions A,G,K,L,N,P revised	KJ/EC	
D	07.06.15	Dimension G revised	KJ/JLM	<i>J.L.M.</i>

DART AEROSPACE LTD				Work Order:	35033
Description: Outer Fwd Saddle				Part Number:	D5951
Inspection Dwg: D5951 Rev: B				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				5"	6"	7"	8"		
A	0.437	0.444		.440	.441	.441	.441		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		5.250	5.250	5.250	5.250		
D	6.995	7.005		7.000	7.000	7.000	7.000		
E	5.245	5.255		5.250	5.250	5.250	5.250		
F	4.745	4.755		4.750	4.750	4.750	4.750		
G	0.315	0.322		.319	.319	.319	.319		
H	1.522	1.532		1.530	1.530	1.530	1.530		
I	3.048	3.058		3.050	3.050	3.050	3.050		
J	4.575	4.585		4.580	4.580	4.580	4.580		
K	0.312	0.319		.319	.319	.319	.319		
L	0.495	0.505		.500	.500	.500	.500		
M	0.490	0.510		.507	.507	.508	.504		
N	1.615	1.635		1.624	1.624	1.624	1.624		
O	7.990	8.010		8.003	8.004	8.004	8.004		
P	2.240	2.260		2.250	2.245	2.245	2.245		
Q	0.307	0.312		.311	.311	.311	.311		
R	0.760	0.765		.760	.760	.760	.760		
S	0.490	0.510		.506	.506	.506	.506		
T	1.375	1.395		1.380	1.380	1.380	1.380		
U	2.000	2.020		2.002	2.002	2.001	2.001		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>J.P.</i>	Audited by:	<i>J.L.</i>
Date:	<i>07/10/13</i>	Date:	<i>07/11/13</i>

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	
C	06.12.06	Dimensions A,G,K,L,N,P revised	KJ/EC	
D	07.06.15	Dimension G revised	KJ/JLM <i>JL</i>	<i>SP</i>

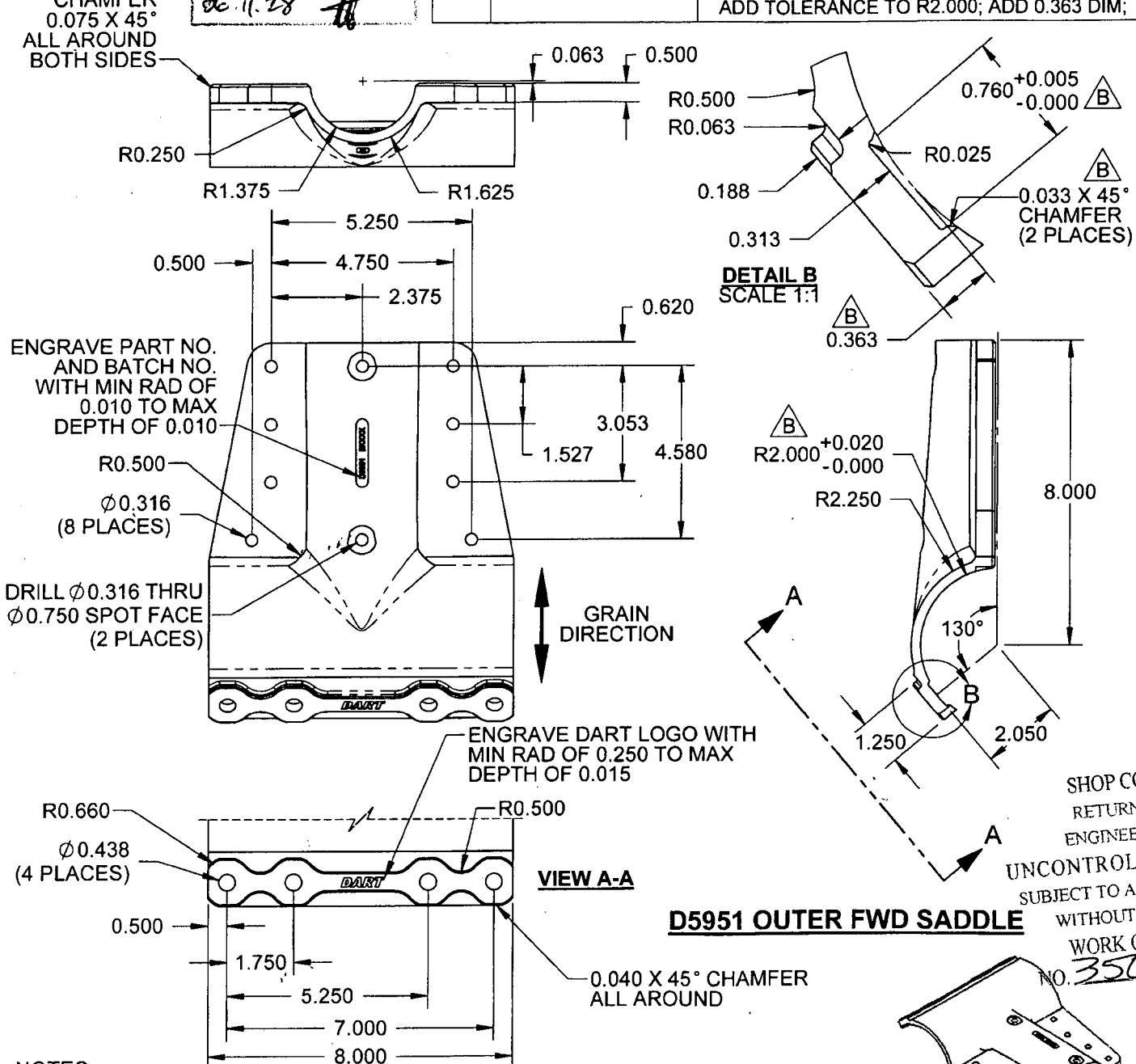
DART

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>CE</i>	APPROVED <i>CH</i>	DRAWING NO. D5951
DATE 06.11.07		REV. B SHEET 1 OF 1 TITLE OUTER FWD SADDLE SCALE 1:4

RELEASED BY

06.11.28

REV	DATE	DESCRIPTION
A	97.05.06	NEW ISSUE
B	06.11.07	INCORPORATE DEO 9102, DEO 9079; ADD 0.363 DIMENSION; Ø 0.316 WAS Ø 0.313; ADD TOLERANCE TO R2.000; ADD 0.363 DIM;



NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 PER QQ-A-250/12
(MAKE FROM D6101-013 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

B

ISOMETRIC VIEW
SCALE 1:8

COPYRIGHT © 1997 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 35033